



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3121-25**Job Sheet 208651****Part No:** D3121-25**Job Qty:** 50 pcs**Part Name:** Delrin Cap**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/27/20**Job Tracking No:****Due Date:** 4/2/20**Created By:** Jennifer Renwick**Type:** SOLD**Description:****Note:** DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	50 pcs	4/2/20	4/2/20	0.50	0.67	Hardinge - 1		66 20/03/31
120	QC 8	50 pcs	4/2/20	4/2/20	0.00	0.00	QC 8 - 12		9-89
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		20-04-01
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
130	Packaging 3-1 - Stock - B4B	50 pcs	4/2/20	4/2/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

Instructions: Various STC's

Date: 03/31/20

Part: D3121-25
Job No: 208651
Serial No/Batch: S267885



Container No: S267885



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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS
				Packaging 3 - 9 - B4B	28
				Packaging 3 - 10 - B4B	9-89
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	50 pcs	4/2/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-89

APR 02 2020

Part Op 100 - Hardinge -1-Turn D3121-25 Cap as per Folio FA387
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINR1.000	Delrin Round Bar 1" Color: Black	1.6500 ft (.033 ea)	100-Hardinge - 1	5262874

Job Allocations

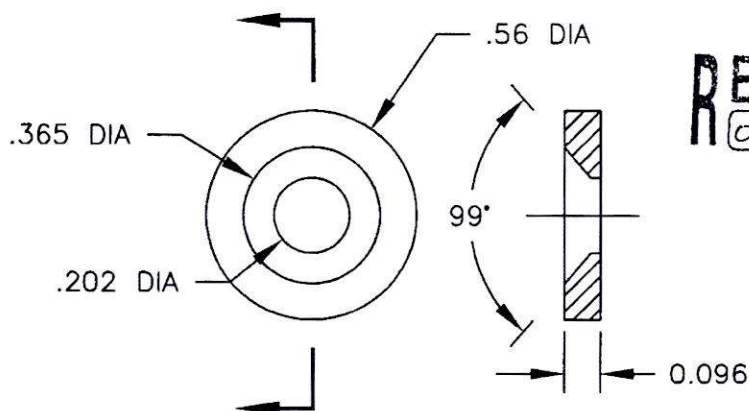
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	MDELRINR1.000	2	9	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches $\pm$ 0.010	0.325 0.305	.314	Mic
2	Cap	1.000inches $\pm$ 0.010	1.010 0.990	1.002	Mic
3	Cap	0.838inches $\pm$ 0.002	0.840 0.836	.838	Pin .837 + Mic
4	Cap	0.063inches $\pm$ 0.010	0.073 0.053	.058	Shad Caliper
5	Cap	0.010inches $\pm$ 0.010	0.020 0.000	.010	
6	Cap	0.230inches $\pm$ 0.001	0.231 0.229	.231	caliper
7	Cap	0.865inches $\pm$ 0.001	0.866 0.864	.866	(118-120)

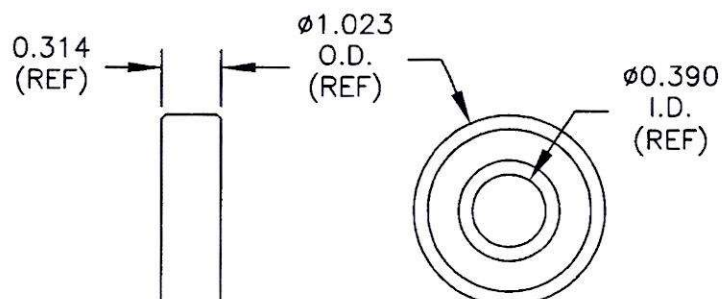
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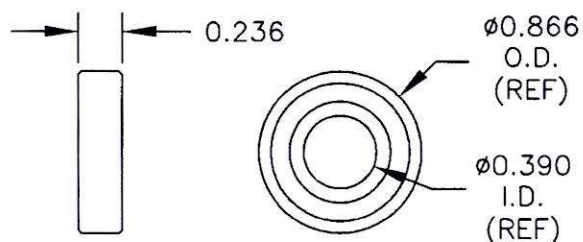
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

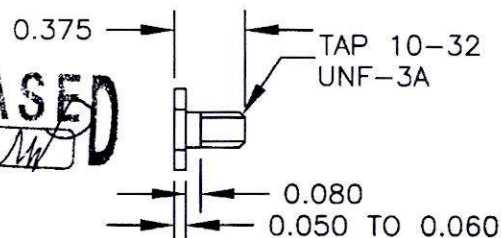
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

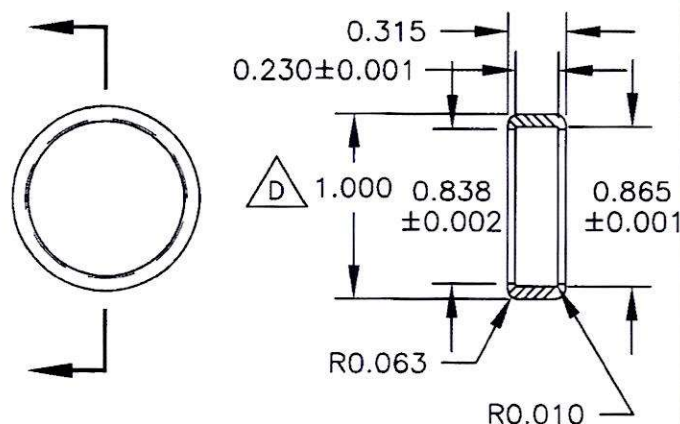
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

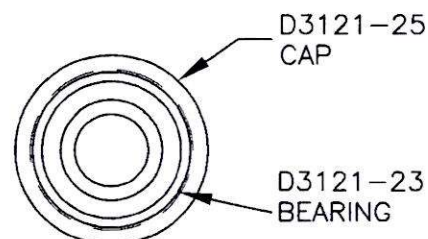
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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